

Work Order ID 63965



Page 1

Monday, November 22, 2010 10:29:46 AM

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 11/22/2010 Start Qty: 14.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

R

Date: 10-11-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

G.A 10/12/22

14

0

Jeaspa Bandsaw

Cut blank 2.90 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

14

0

HAAS CNC vertical machine #1

1- Mill as per Folio FA675Rev: *AA* & Dwg D3571 Rev: *A* ☐ 2-Deburr
per dwg D3571

G.A 10/12/22

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

G.A 10/12/22

14

0

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 63965

Monday, November 22, 2010 10:29:46 AM



Page 2

| | | | | | | |
|----------------|------------|------------|-------|-------|---------------|--|
| Item ID: | D3571-1 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Guide | | | | | |
| Start Date: | 11/22/2010 | Start Qty: | 14.00 | | Cust Item ID: | |
| Required Date: | 11/30/2010 | Req'd Qty: | 14.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | 14 | 0 | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 14 | 0 | | BR 10-12-23 |
| 150 Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 10:15 322° FINISH TIME: 10:45 | 0.00 0.00 | | | | 14 | 0 | | BR 10-12-23 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 63965

Monday, November 22, 2010 10:29:46 AM



Page 3

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 11/22/2010 Start Qty: 14.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

=) JH 11/01/07

14 0



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 245

0.00



Packaging

Memo

0.00

Packaging

11/01/03 (14)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03
CL 11/01/03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Monday, November 22, 2010 10:29:51 AM

Page 1

Work Order ID: 63965



Parent Item: D3571-1



Parent Item Name: Guide

Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X01.50 0 | | Purchased | No | | | 100 | f | 23.0000 | 0.241 | 3.551579 | | | |



6061-T6 Bar .750 X 1.50

| Location | Loc Qty | Loc Code |
|-------------|---------|----------|
| MAT | 20 | |
| 116135 | 20 | |
| MAT028 | 3 | |
| (10) 114968 | 3 | |
| (4) 116405 | | |

2.5367 ft
1.0147 ft

A-A 10/12/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 43945 |
| Description: Guide | | Part Number: | D3571-1 |
| Inspection Dwg: D3571 | Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------------|------------------|--------|--------|----------------------|---------------|
| 0.698 | +/-0.010 | 0.699 | ✓ | | Vern | GA-01 |
| Ø1.00 Depth 100 | +/-0.010 | Ø1.001 x 0.100 | ✓ | | D-6/Vern | GA-01 / GA-08 |
| 2.75 | +/-0.030 | 2.752 | ✓ | | Vern | GA-01 |
| 1.38 | +/-0.030 | 1.375 | ✓ | | " | " |
| 1.25 | +/-0.030 | 1.249 | ✓ | | " | " |
| 0.63 | +/-0.010 | 0.624 | ✓ | | " | " |
| 0.031 chamfer | +/-0.010 | 0.032 | ✓ | | " | " |
| Ø0.500 | +0.006/-0.001 | 0.501 | ✓ | | " | " |
| Ø0.201 | +0.005/-0.001 | Ø0.202 | ✓ | | " | " |
| R0.25 | +/-0.030 | R0.250 | ✓ | | R-6 | ref. |
| 0.260 | +0.000/-0.010 | 0.256 | ✓ | | Vern | GA-01 |
| Ø0.385 x 100° | +0.006/-0.001 x 0.5° | Ø 0.383 x 100° | ✓ | | Vern | GA-01 |
| 0.125 | +/-0.010 | 0.126 | ✓ | | " | " |
| 2.250 | +/-0.010 | 2.247 | ✓ | | " | " |
| 0.250 | +/-0.010 | 0.252 | ✓ | | " | " |
| 0.188 | +/-0.010 | 0.190 | ✓ | | " | " |
| 0.063 chamfer | +/-0.010 | 0.063 | ✓ | | " | " |
| | | | | | | |
| | | | | | | |
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| | | | |
|-------------------------|-------------------------------|----------------------------|-----|
| Measured by: Y.A | Audited by: <i>amb</i> | Prototype Approval: | N/A |
| Date: 10/12/22 | Date: 10/12/22 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 07.04.16 | New Issue | KJ/JLM | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

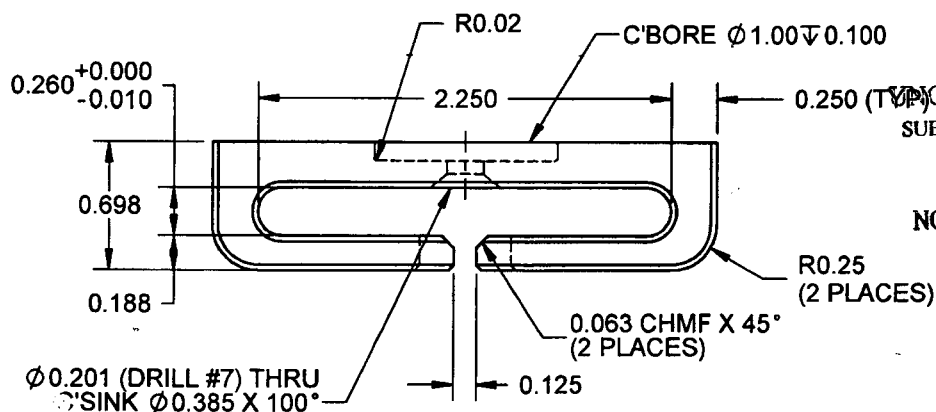
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

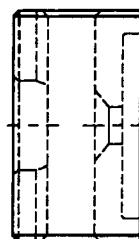
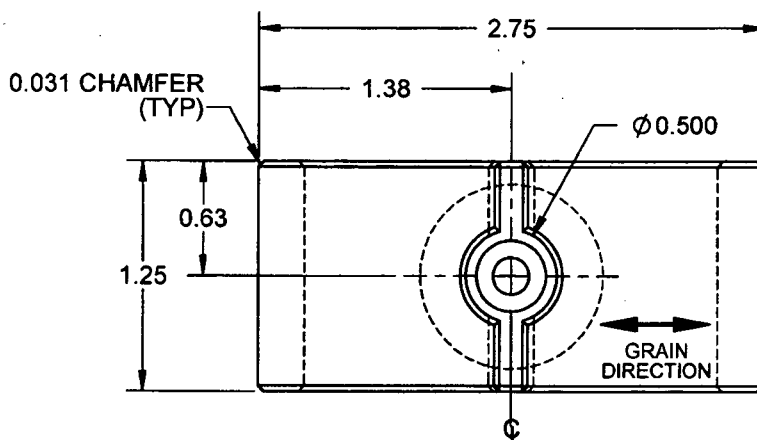


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|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3571 | REV. A SHEET 1 OF 2 |
| DATE 07.01.29 | TITLE GUIDE | | SCALE 1:1 |
| REV A | DATE 07.01.29 | DESCRIPTION NEW ISSUE | |

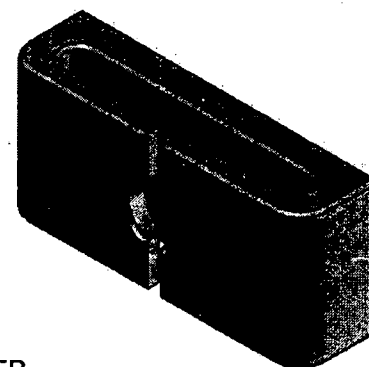
RELEASED
07.04.12 *[Signature]*



SHOP COPY
RETURN TO
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CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63965*
12/10/11/22



D3571-1 GUIDE



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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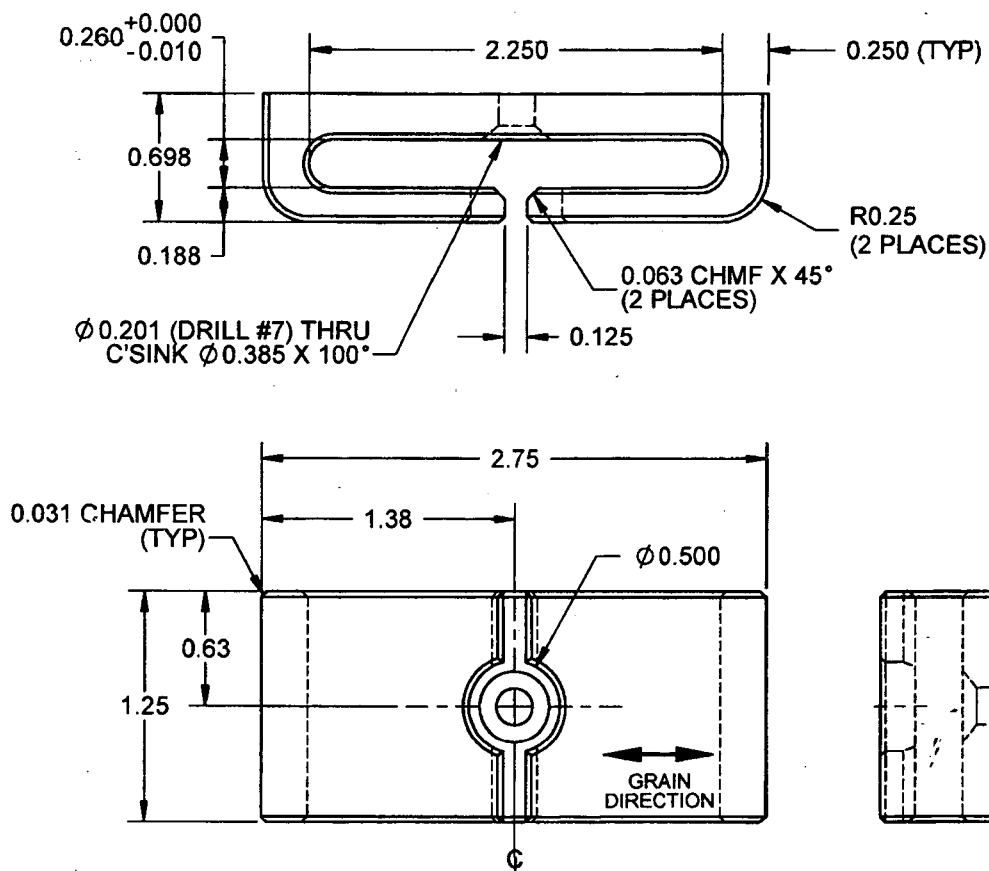
NOTE: Date & initial all entries



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|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3571 | REV. A SHEET 2 OF 2 |
| DATE 07.01.29 | | TITLE GUIDE | SCALE 1:1 |

RELEASED
07.04.12 *[Signature]*

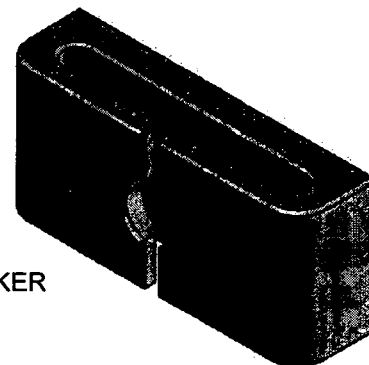
u/o 63905



D3571-3 GUIDE

NOTES:

- 1) MATERIAL. 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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